

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008254**Date Inspected:** 02-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Jin Dong Liang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY#10

Visual Inspection and Magnetic Particle Inspection

This QA Inspector performing random Visual testing and approximately 15% Magnetic particle testing of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (MT) report for this date. The members are identified as the North Tower, Lift 1, Skin E the welds Designation are as follows.

NSD1-SA10A/K-1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12.

Green tag No: 8367

NSD1-SA10B/K-1, 2, 3, 4, 5, 6.

Green tag No: 8367

This QA Inspector randomly observed the following work in progress

BAY#10

FCAW welding process of weld joint 94B located on PCMK SSD1-FASA4-1E/E. Welder is identified as 050041 ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the

WELDING INSPECTION REPORT

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WPS-B-T-4231-B-U3-F.

FCAW welding process of weld joint 46B located on PCMK SSD1-FASA4-1E/E. Welder is identified as 048378 ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U3-F.

FCAW welding process of weld joint 20 located on PCMK NSD1-FASA3-1C/E. Welder is identified as 052075 ZPMC QC is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

SAW welding process of weld joint 4B located on PCMK NSD1-TL8B/L. Welder is identified as 040489 ZPMC QC is identified as Wei song Shi. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221C-U2B-S

FCAW welding process of weld joint 26 located on PCMK NSD1-FDSA3-1C/C. Welder is identified as 040533 ZPMC QC is identified as Jin Dong Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F

FCAW welding process of weld joint 61B located on PCMK SSD1-FASA4-1E/E. Welder is identified as 050041 ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-4231-B-U3-F.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar, Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
